

SHIP ASAP 13-14/04 /

Dart Aerospace Ltd.

Date: Thursday, 09/04/2009 10:41:37 AM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BRACKET ASSEMBLY
<b>Job Number</b> : 47101	
<b>Estimate Number</b> : 11181	
<b>P.O. Number</b> :	<b>Part Number</b> : D32941
<b>This Issue</b> : 09/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3294 REV.C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 45818	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 13/04/2009 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est A 04.08.24 New issue KJ/JLM	
Est Rev:B Now On Waterjet 07-03-26 JLM	
Est Rev:C 08-07-16 Redesign part DD verified by:EC	
Est Rev:D 08-10-06 revB as per dwg DD verified by:EC	
Est Rev:E 09-04-08 redesign part (rev.c) DD verified by:	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S080	2024-T3 .080 sheet
-----	-------------	--------------------



Comment: Qty.: 1.8976 sf(s)/Unit Total : 18.9756 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.080" thick  
(M2024T3S.080)

Identify for D3294-1

Batch: 110908

B 9-4-13

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3294-3F

Dwg Rev: C

Prog Rev: C

\*\*\*\*\*grain direction on a 45 deg as per dwg\*\*\*\*\*

2-Deburr if necessary

B 9-4-13

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Seen the sheet on water jet for  
Grain Direction

509/04/13 (x10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 09/04/2009 10:41:37 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 47101

Part Number: D32941

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- deburr if necessary

2- Bend as per Dwg D3294

(Ensure angle is correct)

SB 09/04/13

(10)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/04/13

(10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SB 09-04-14

(10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 09/04/14

(10)

9.0

D32945

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Doubler

Batch: B 47102

SB 09/04/14

(10)

10.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 15.0000 Each(s)/Unit Total : 150.0000 Each(s)

Rivet, Universal Head

Batch: M 109031

SB 09/04/14

(10)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install D3294-5 doubler to D3294-3 bracket with rivets as per dwg D3294

SB 09/04/14

(10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 09/04/2009 10:41:37 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 47101

Part Number: D32941

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/14 (X10)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M 105042

START TIME:

11:30

OVEN TEMPERATURE:

350°

FINISH TIME:

12:00

BL

09-04-14

(10)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

09-04-14

(X10)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N using fine point permanent ink marker, then Stock

Location:

PPP47103, 47104

S 09/04/14 (X10)

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



mf 09-04-14

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47101
<b>Description:</b> BRACKET ASSEMBLY		<b>Part Number:</b> D3294-1
<b>Inspection Dwg:</b> D3294-1 <b>Rev:</b> C		<b>Page 1 of 2</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

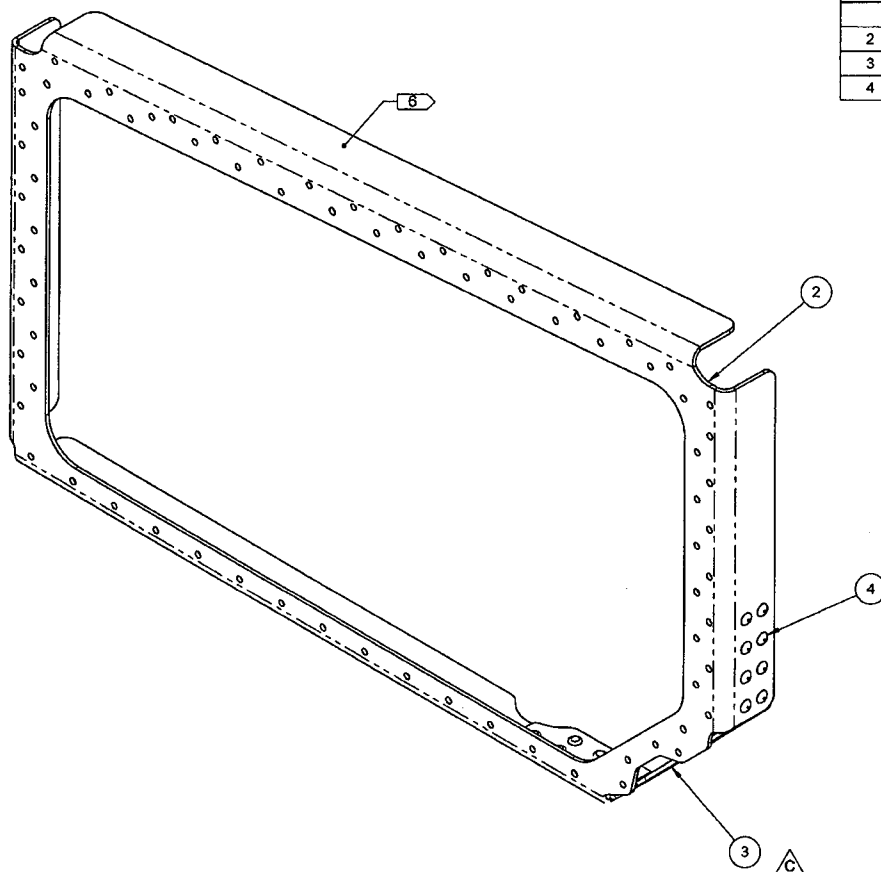
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .128	+ .004 - .001	.131	✗			
Ø .141	+ .005 - .001	.142	✗			
17.124	+/- .010	17.125	✗			
5.000	+/- .010	4.998	✗			
1.000	+/- .010	1.000	✗			
6.000	+/- .010	6.000	✗			
.625	+/- .010	<del>.625</del>	✗			
.300	+/- .010	.298	✗			
.400	+/- .010	.402	✗			
3.293	+/- .010	3.293	✗			
13.563	+/- .010	13.563	✗			
1.043	+/- .010	1.043	✗			
5.590	+/- .010	5.587	✗			
1.118	+/- .010	1.119	✗			
6.708	+/- .010	6.707	✗			
1.118	+/- .010	1.119	✗			
20.05	+/- .030	20.05	✗			
16.13	+/- .030	16.13	✗			
7.27	+/- .030	7.267	✗			
12.98	+/- .030	12.98	✗			
4.19	+/- .030	4.194	✗			
.50	+/- .030	.504	✗			
.82	+/- .030	.828	✗			

<b>Measured by:</b> JB	<b>Audited by:</b> S	<b>Prototype Approval:</b> A
<b>Date:</b> 9-3-14	<b>Date:</b> 09/04/13	<b>Date:</b> 07

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



ITEM NO.	QTY. -1	PART NUMBER	DESCRIPTION
1	X	D3294-1	BRACKET ASSEMBLY
2	1	D3294-3	BRACKET
3	1	D3294-5	DOUBLER
4	15	MS20470AD4-5	RIVET



**D3294-1 BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1 AND B/N" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6.	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.24		

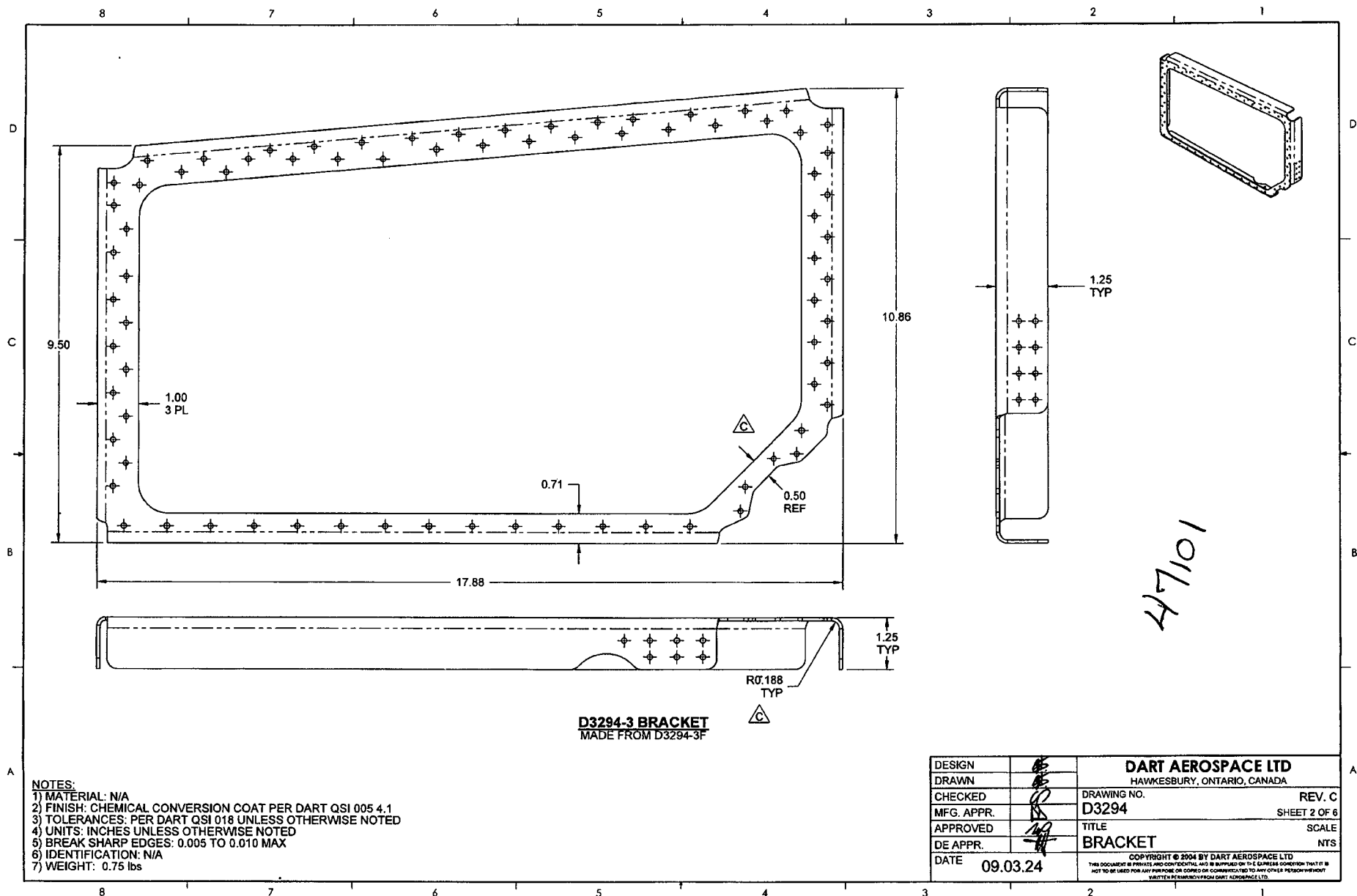
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

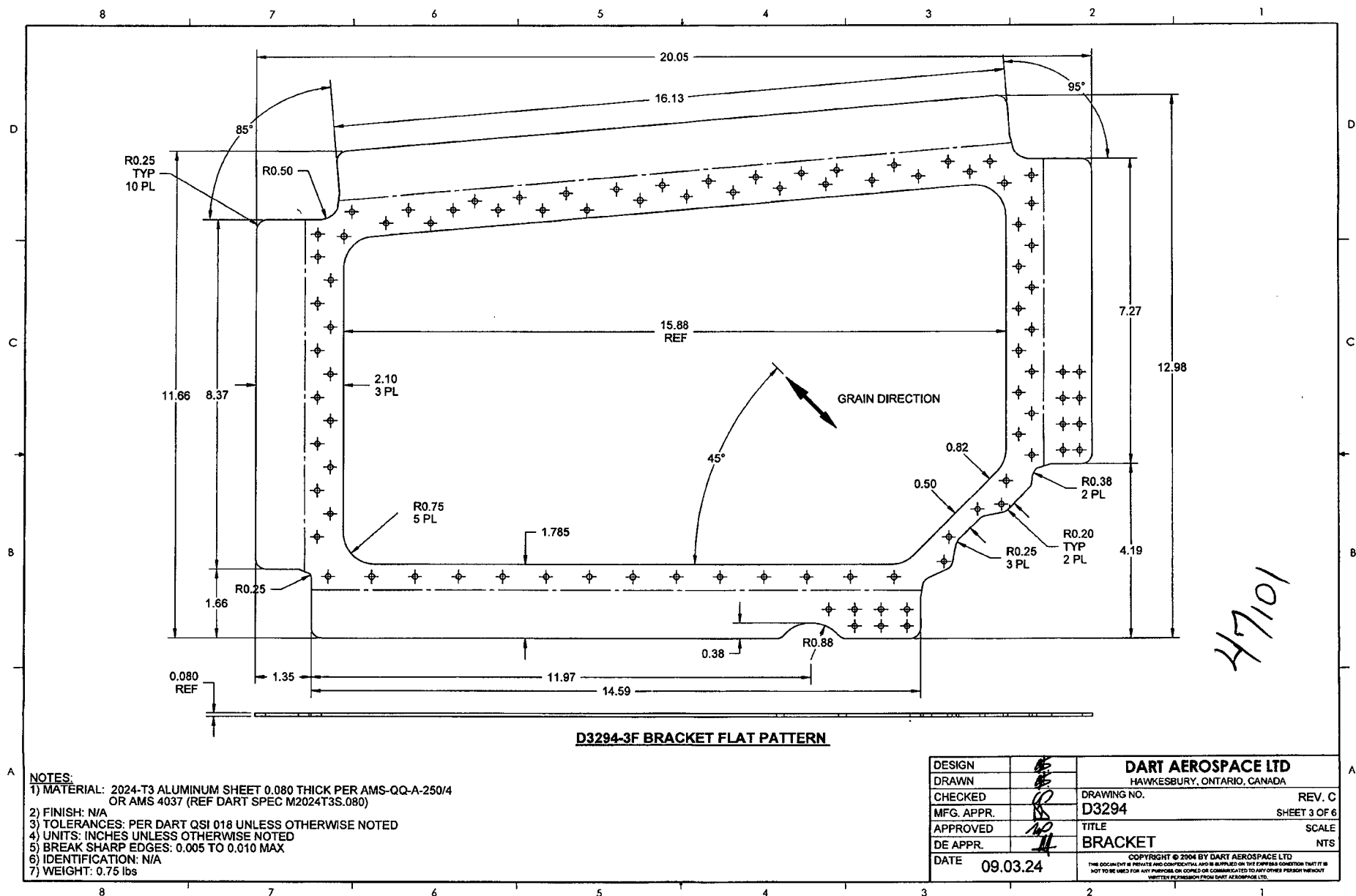
DRAWING NO. D3294  
REV. C  
SHEET 1 OF 6

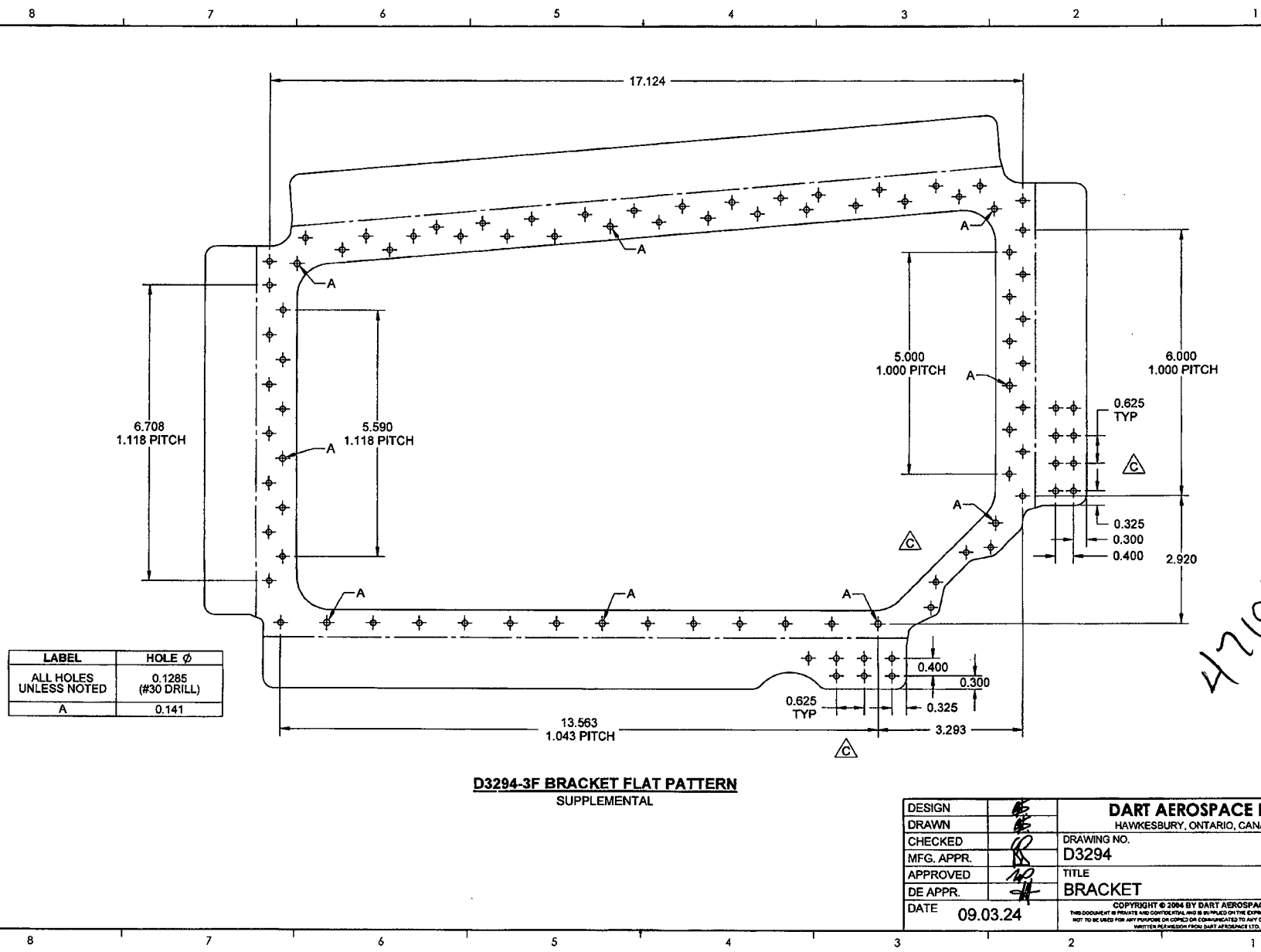
TITLE BRACKET  
SCALE NTS

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LABEL	HOLE $\phi$
ALL HOLES UNLESS NOTED	0.1285 (#30 DRILL)
A	0.141

**D3294-3F BRACKET FLAT PATTERN**  
SUPPLEMENTAL

DESIGN	42
DRAWN	42
CHECKED	42
MFG. APPR.	42
APPROVED	42
DE APPR.	42
DATE	09.03.24

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3294</b>	REV. C SHEET 4 OF 8
TITLE <b>BRACKET</b>	SCALE NTS
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